

Work Order ID 84632-1

84632

Page 1

May-17-12 11:51:28 AM

Item ID: D3875-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector

Start Date: 17/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 12/05/22 Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3875

Rev A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 POLYCARBONATE

Temp:

Time IN:

Time OUT:

4:30

12/05/22

7:00

12/05/22

G

12/05/22

G

12/05/22

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Process Plan:

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

110

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435
Dwg Rev: A
Folio Rev: B

0.00

0.00

6

B 12/05/29

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Visually inspect part for proper formation and texture

0.00

6

B 12/05/29

130

130

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

6

dh.
12/05/29

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Page 3

Setup Start *NS1*

Stop *NS2*

Customer:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Code	Qty	Unit	Number	Stamp
140	0.00			
140				
HandThermo				
Hand Finishing Thermoforming				
Memo	0.00			
1-Trim to finished dimensions as per Dwg				

12/05/29

150	QC2- Inspect parts off machine FAI/FAIB	0.00	
150			
QC	Memo	0.00	<u>x/</u> <u>DL</u>
Quality Control	Complete FAI document		<u>12/05/24</u>

160	QC5- Inspect part completeness to step on W/O.	0.00	
160			
QC	Memo	0.00	8/21/29
Quality Control			

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Page 4

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Accept

N900040100

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Revision ID:

Item Name: Floor Protector

Stop ***NS2***

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Required Date: 31/05/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/30

MF
12-05-09

Picklist Print

May-17-12 11:51:31 AM

Page 1

Work Order ID: 84632

84632

Parent Item: D3875-1

D3875-1

Parent Item Name: Floor Protector

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,181.636	9.84	39.36			

MI FXS 118-90318-08

**

Lexan Sheet

Location

therm

113127

Loc Qty

1181.636941

1181.63694

Loc Code

9.84 sk 12/05/09

DART AEROSPACE LTD		Work Order:	24632
Description: Floor Protector		Part Number:	D3875-1
Inspection Dwg: D3875	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/4"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: JB

Date: 12/05/25

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.051"	✓		Visual DL-02	
0.080	Min	0.096"	✓		CAL TH DT	
45.2	+/-0.100	45.3"	✓		TAPE DL-01	
21.8	+/-0.100	21.8"	✓		TAPE DL-01	
1.4	+/-0.100	1.41"	✓		Visual DL-02	

Measured by: JB

Audited by: JB

Prototype Approval:

N/A

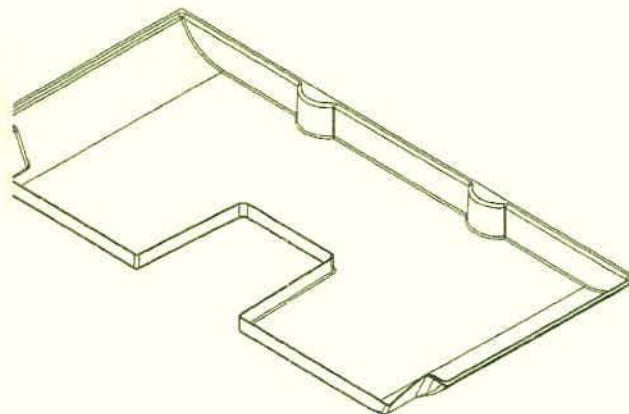
Date: 12/05/25

Date: 12/05/27

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	JA





D3875-1 FLOOR PROTECTOR (206B)

), 0.118 THICK, 112-CLEAR

HERWISE NOTED

3875-1" USING VIBRATING STYLUS

PER DART QSI 022. TRIM PER MOLD
(WN)

SHOUP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84632 MLJ
12/05/22

RELEASED
29/05/25 NAB

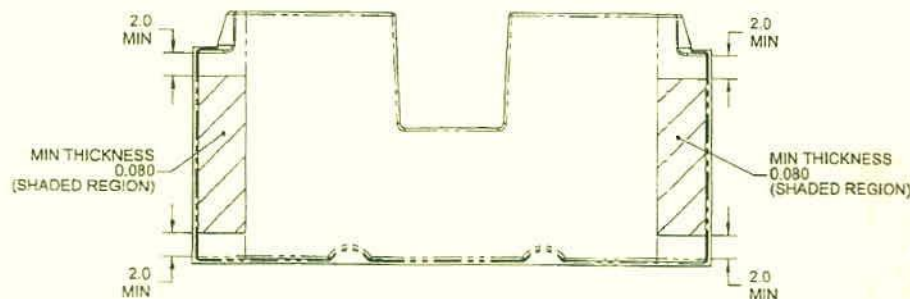
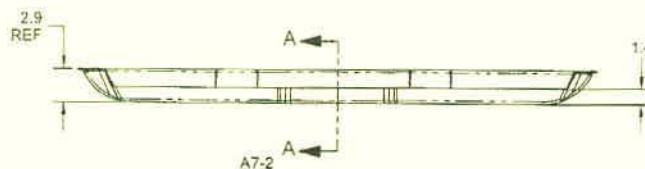
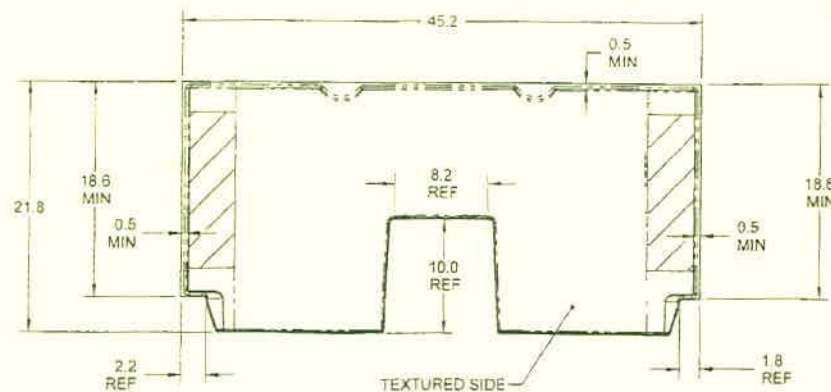
A	NEW ISSUE	PH	09.01.29
REV	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	09.01.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3875
TITLE FLOOR PROTECTOR (206B)
REV. A
SHEET 1 OF 2
SCALE NTS

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84632



SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

RELEASED
29/05/05

DESIGN	PA	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR	PA	D3875	SHEET 2 OF 2
APPROVED	PA	TITLE	SCALE
DE APPR	PA	FLOOR PROTECTOR (206B)	NTS
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